



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C2-3-3-1
Job Sheet 171609



Part No: C2-3-3-1

Job Qty: 30 ea

Part Name: Latch Roller DU Bearing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/5/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: C2-3-3-1 REV.A IPP REV:A 18.02.02 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		2/15/18	0.00	0.00	Start Up Machining-4		
120	CNC Lathe	30 pcs		2/16/18	0.50	3.00	Lathe Conv-1		
130	QC	30 pcs		2/16/18	0.00	0.00	QC2 Machining-5		
140	QC	30 pcs		2/16/18	0.00	0.00	QC8 Machining-5		
150	Packaging	30 pcs		2/16/18	0.00	0.00	Packaging3-2		
160	QC21-FG	30 Ea		2/16/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per DWG DWG REV: _____ 2-Debur

Descriptions: 150 - BAG & LABEL WITH BATCH # AS PER DWG NOTE

DAS
21
9-80

MAR 7 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
05DU06	Latch Roller DU Bearing	30 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	05DU06	30	0	0

Part Specifications

Specifications could not be found.

Plex 2/5/18 3:35 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

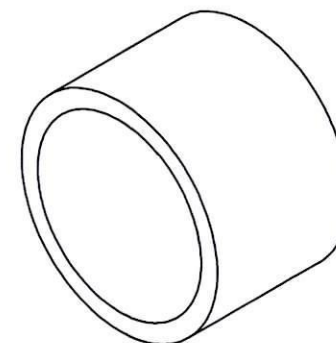
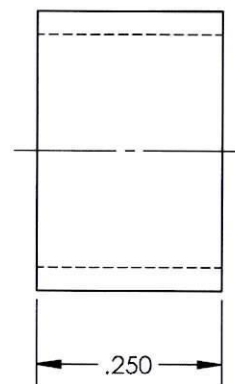
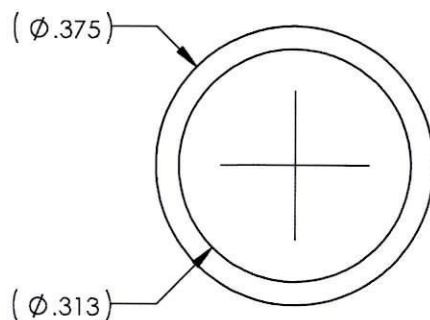
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																															
Description Work Order Deviation			Disposition																																																																																
Dart Aerospace Ltd. 1270 Aberdeen Street Leventhorpe, ON K6L 1K7 CANADA TEL: 1 813 692-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 03/12/18 Container No: S050472 Part: C2-3-3-1 Job No: 171609 Serial No/Batch: S050472 Revision: A Inspector:			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: left;">Root Cause</th> <th colspan="2"></th> <th colspan="2"></th> </tr> <tr> <td style="width:15%;">Environment</td> <td>☐</td> <td style="width:15%;">No Re-verfic</td> <td>☐</td> <td style="width:15%;">Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td>m</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setu</td> <td>☐</td> <td></td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td></td> <td>☐ Part Incorrect</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>← Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Test</td> <td>☐</td> <td>ence</td> <td>☐ Part Moved</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td></td> <td>☐ Drawing</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td></td> <td>☐ Finish</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td></td> <td>☐ Misread</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td></td> <td>☐ Turning Sequence</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td></td> <td></td> </tr> </table>						Root Cause						Environment	☐	No Re-verfic	☐	Surge	☐ Positioned Wrong	Design	☐	Operator	☐	m	☐ Outside Dimensions	Doc/Data	☐	Offset/Setu	☐		☐ Over/Under tolerance	Equip/Tooling	☐	Supplier	☐		☐ Part Incorrect	Handling/Pre	☐	Training	☐	← Pulled	☐ Part Lost/Missing	Material	☐	Use for Test	☐	ence	☐ Part Moved	Internal Transport	☐	Poor Information	☐		☐ Drawing	Tribal Knowledge	☐	Rushing	☐		☐ Finish	LOA	☐	Product Improvement	☐		☐ Misread	Substation	☐	Process Improvement	☐		☐ Turning Sequence	Past Expiry Date	☐	Manufacturing Process	☐			Misidentified	☐	Past Due	☐		
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
A	14-0105	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED NOTE 3.	8/6/2014	DPD
				APPROVED RW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171609 ML5
19-02-05

NOTES:

1. PART TO BE FABRICATED FROM 05DU06 DU BEARING. CUT LENGTH TO INDICATED DIM.
2. CLEAN THE CUT EDGE.
3. BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LATCH ROLLER DU BEARING	
DWG NO. C2-3-3-1	REV A
MAT'L BRONZE	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT FINISH SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 4:1	DATE 5/10/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C2-3-3-1	1	LATCH ROLLER DU BEARING	BRONZE	KAMAN #05DU06 (MODIFIED)

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
SHOP COPY CONTROLLED COPY WORK ORDER								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					